

Friday, October 14, 2016 1:55:29 PM

Page 1

120	QC5- Inspect part completeness to step on W/O	0.00	
120			
QC	Memo	0.00	
Quality Control			NOV 25 2016

Work Order ID 151928

Friday, October 14, 2016 1:55:29 PM

151928

Page 2

Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly (350)
Start Date: 10/13/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PPP 152399	0.00 0.00			DAS 27 9-89	DAS 28 9-89			
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							16/11/29 J

9106 8 2 NON

DAS
21
9-89

NOV 2 8 2016

Picklist Print

Friday, October 14, 2016 1:55:28 PM

Page 1

Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	1.0000	1	1			DAS 6 9-89

Location Loc Qty Loc Code

ST379
146564

1
1

D2535

Manufactured No

100

Each

62.0000

2

2

NOV 24 2016
DAS
6
9-89

D2535

Spring

Location Loc Qty Loc Code

ST008
144488
146275
148592

62
12
25
25

D2537

Manufactured No

100

Each

66.0000

2

2

NOV 24 2016

D2537

Bushing

Location Loc Qty Loc Code

ST008
141583
145899
148918

66
1
40
25

D3913-041

Manufactured No

100

Each

0.0000

1

1

D3913-041

Long Basket Base Assembly, 350

**

x1 #151925 2016/11/24
BEB

Picklist Print

Friday, October 14, 2016 1:55:28 PM

Page 2

Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

D3914-041 Manufactured No

100 Each 0.0000 1 1

D3914-041

Long Basket Lid Assembly (350)

****** *1 B# 152404 2016/11/24 BETB.*

D3917-3 Manufactured No

100 Each 69.0000 6 6

D3917-3

Washer

****** *NOV 7 1 2016* **DAS 6 9-89**

Location	Loc Qty	Loc Code
ST058	69	
146855	20	
147428	25	
<u>148671</u>	24	

3
2

D3953-3 Manufactured No

100 Each 46.0000 2 2

D3953-3

Gas Spring Stud, Lid

****** *NOV 7 1 2016* **DAS 6 9-89**

Location	Loc Qty	Loc Code
ST062	24	
144775	4	
149582	20	
ST064A	22	
147675	10	
148400	12	

2

D3953-7 Manufactured No

100 Each 36.0000 2 2

D3953-7

Spring Spacer

****** *NOV 2 4 2016* **DAS 6 9-89**

Location	Loc Qty	Loc Code
ST062	8	
144665	8	
ST064A	28	
147641	16	
<u>148382</u>	12	

2

Picklist Print

Friday, October 14, 2016 1:55:28 PM

Page 3

Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

100 Each 67.0000 2 2

D3953-9

Gas Spring Washer

DAS
6
9-89

NOV 2 4 2016

Location

Loc Qty

Loc Code

ST062

12

147022

12

ST064A

55

145912

55

D3953-17

Manufactured No

100 Each 42.0000 2 2

D3953-17

Gas Spring Spacer

DAS
6
9-89

NOV 2 4 2016

Location

Loc Qty

Loc Code

ST062

42

145690

13

147373

13

149542

16

D3953-19

Manufactured No

100 Each 32.0000 1 1

D3953-19

Gas Spring Bracket

DAS
6
9-89

NOV 2 4 2016

Location

Loc Qty

Loc Code

ST062

18

138913

2

145653

16

ST064A

14

147350

14

Picklist Print

Friday, October 14, 2016 1:55:28 PM

Page 4

Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

D3953-21 Manufactured No

100 Each 28.0000 1 1

D3953-21

Gas Spring Bracket

NOV 24 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

ST063

28

145806

14

147443

14

D3969-3

Manufactured No

100 Each 17.0000 1 1

D3969-3

Spring (Basket Lid)

NOV 24 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

ST365

17

144499

7

148841

10

AN3-14A

Purchased No

100 Each 91.0000 4 4

AN3-14A

Bolt

NOV 24 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

over003

80

m135056

50

m135600

30

ST349

11

m134360

2

m134852

9

Picklist Print

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Page 5

Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-16A

Purchased

No

100

Each

66.0000

2

2

AN3-16A

Bolt

**

136044

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

45

117441

45

ST348

21

M133790

5

M134943

16

AN5-17A

Purchased

No

100

Each

134.0000

4

4

AN5-17A

Bolt

**

Location

Loc Qty

Loc Code

GA

29

117872

29

over003

75

m135297

75

ST337

30

m134606

3

m134762

27

AN4-12

Purchased

No

100

Each

70.0000

3

3

AN4-12

Bolt

**

Location

Loc Qty

Loc Code

ST344

70

m134370

1

m134738

19

m135046

25

m135408

25

NOV 24 2016

DAS
6
9-89

Picklist Print

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Page 6

Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

AN310-4

Purchased

No

100

Each

135.0000

3

3

AN310-4

Nut

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

50

M135704

50

ST331

60

M134955

1

M135442

59

3

AN310C4

Purchased

No

100

Each

73.0000

2

2

AN310C4

Nut

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

OVER007

29

M135297

29

ST331

44

M134762

44

2

Picklist Print

Friday, October 14, 2016 1:55:28 PM

Page 7

Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

1,603.000

6

6

MS21042L3

Nut

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

225

m134360

108

m135135

117

OVER007

600

m135767

600

ST303

771

m135530

600

m135600

171

MS21042L5

Purchased

No

100

Each

392.0000

4

4

MS21042L5

Nut

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

53

m127813

53

ST303

339

m135297

166

m135442

3

m135544

100

m135774

70

Picklist Print

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Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

147.0000

3

3

MS24665-151

Cotter Pin

DAS
6
9-89

Location

Loc Qty

Loc Code

NOV 24 2016

GA

60

m128401

60

ST289

87

m135274

87

3

MS24665-300

Purchased

No

100

Each

125.0000

2

2

MS24665-300

COTTER PIN

DAS
6
9-89

Location

Loc Qty

Loc Code

NOV 24 2016

GA

28

118234

28

ST288

97

m135046

97

2

NAS1149F0432P

Purchased

No

100

Each

1,473.000

6

6

NAS1149F0432P

WASHER

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST260a

1000

M135704

1000

ST262

473

M134955

473

6

NAS1149F0563P

Purchased

No

100

Each

176.0000

4

4

NAS1149F0563P

Washer

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST262

176

m134852

176

4

Picklist Print

Friday, October 14, 2016 1:55:28 PM

Page 9

Work Order ID: 151928

151928

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 10/13/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

1,384.000

8

8

NAS1149F0332P

Washer

**

135948

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

282

m133709

282

ST262

1102

m135544

1102

NAS1149C0432R

Purchased

No

100

Each

1,293.000

2

2

NAS1149C0432R

WASHER

**

135979

NOV 24 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

800

m125807

427

m134676

373

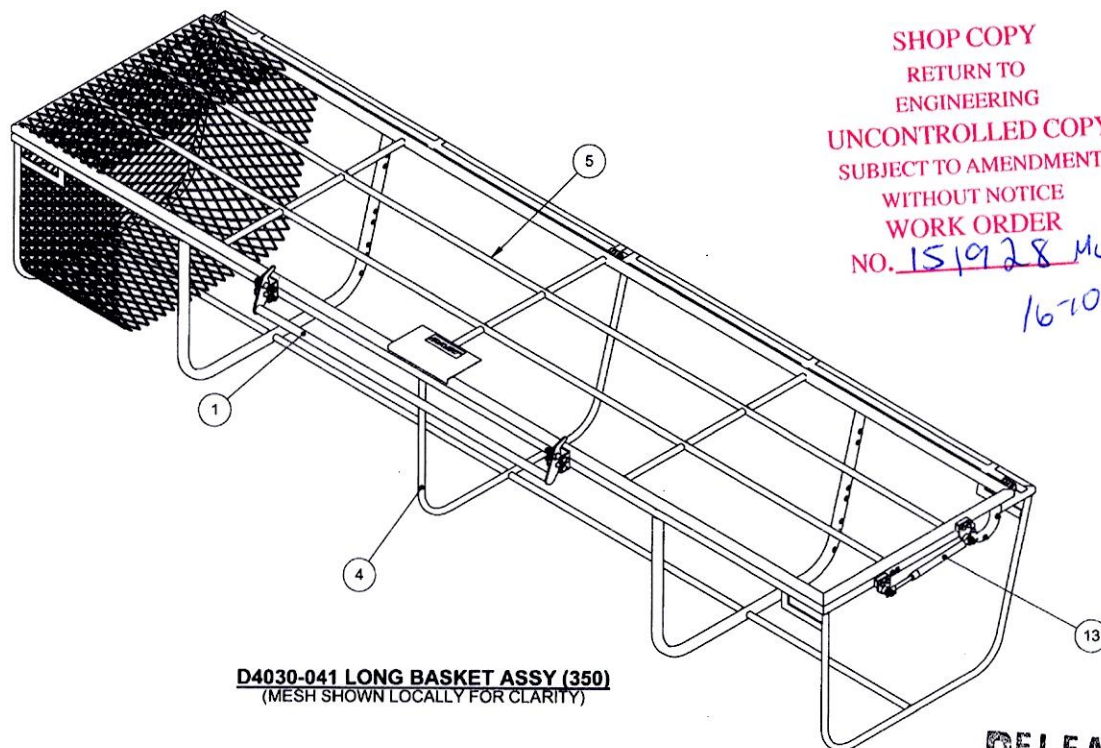
ST266

493

m135544

493

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

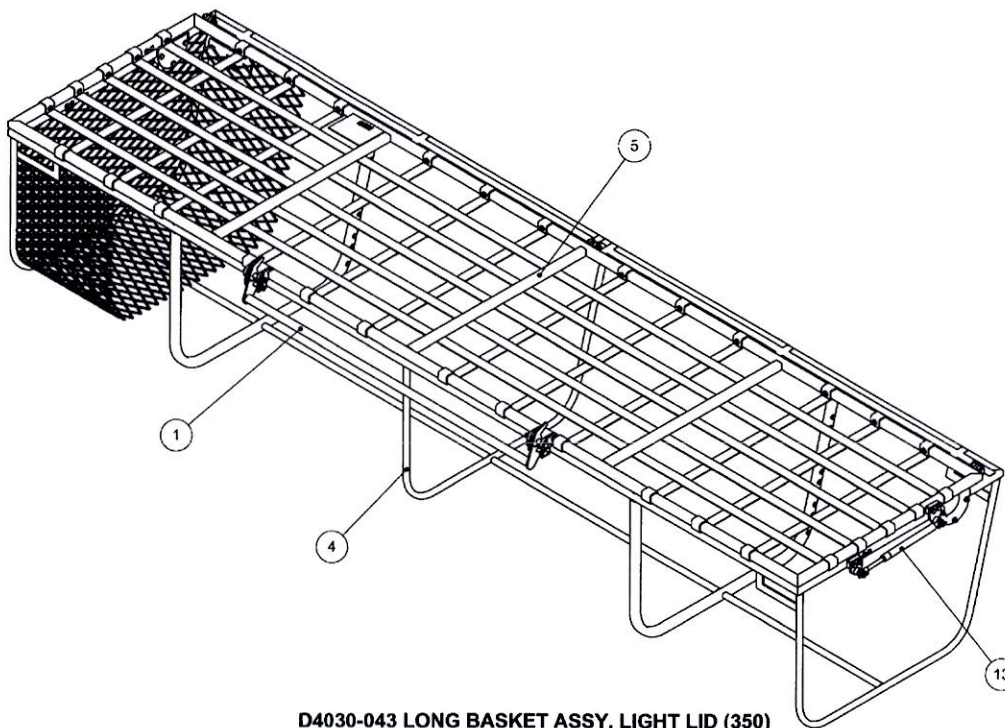
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151928 MJS
1670-77

RELEASED
2013-08-16

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 72 lbs APPROX

D	REFORMAT FOR CLARITY, PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	ANS-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	UP	DRAWING NO.	REV. D
MFG. APPR.	AS	D4030	SHEET 1 OF 4
APPROVED	SW	TITLE	SCALE
DE APPR.	—	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER



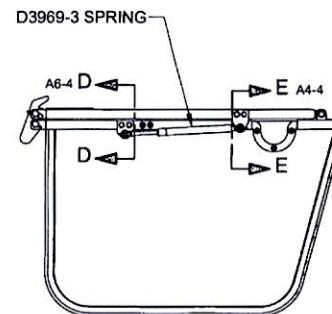
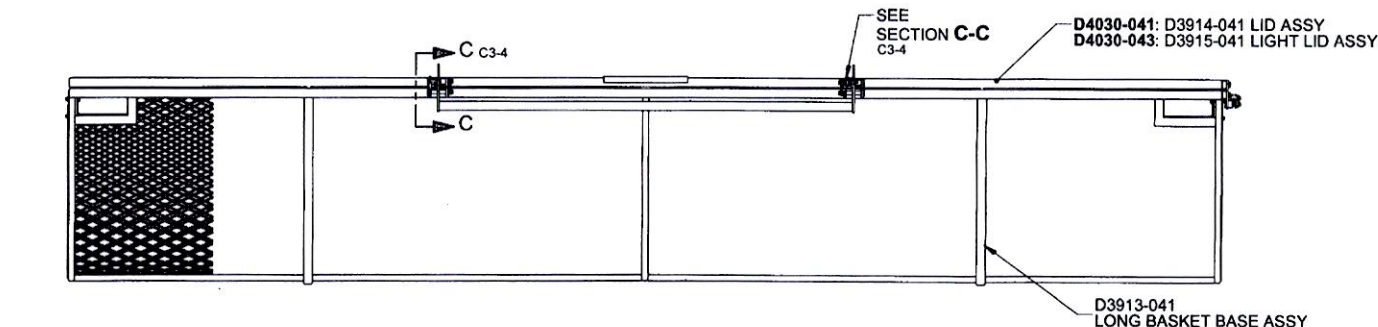
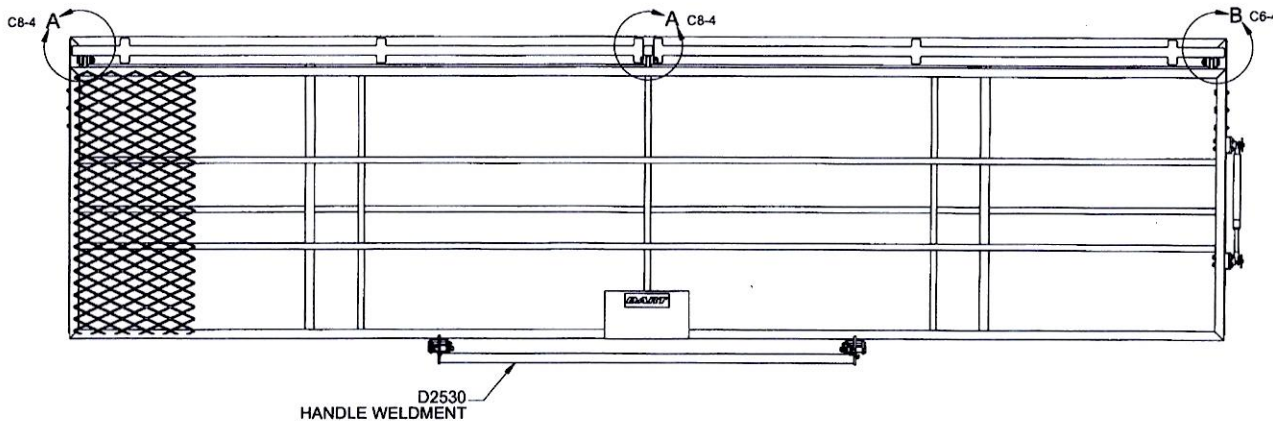
D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
R 2013-08-16
MP

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

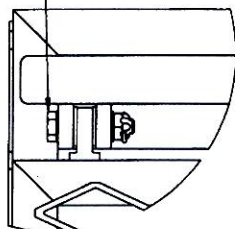
D4030-043 SHORT BASKET ASSY, LIGHT LID (350) (SIMILAR)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

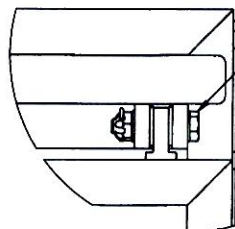
RELEASED
2013-08-16

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



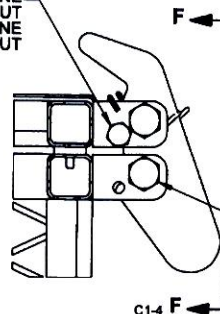
DETAIL A D8-3
D5-3

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-3

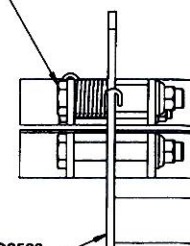
D4030-041: AN3-16A BOLT, MACHINE
MS21042L3 NUT
D4030-043: AN3-20A BOLT, MACHINE
MS21042L3 NUT



SECTION C-C B4-3
B6-3

D4030-041: AN5-17A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT, MACHINE
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-4

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-3

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-3

RELEASED
2013-08-16
AM

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MFG. APPR.		D4030	SHEET 4 OF 4
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